

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028904**Date Inspected:** 20-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No
Component:	Miscellaneous Steel	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Scott A Leavitt, arrived at USA Hoist, in Crest Hill, IL and met with Tim Moran, USA Hoist Company, Project Manager. The purpose of the visit was to witness fabrication of material for elevator landing gates.

Observed work in progress related to CCO 85.

Observed the following work: FCAW CJP's and tack welds on Door Assemblies for Stop 1 and 4. Welders are identified as Matt Wasiqi (A) and Genaro Ulloa (D). Mr Wasiqi was FCAW CJP welds on the frame of the Door Assembly for Stop 1. Performed a random check of electrical parameters for shop WPS FCAW2915 (B-U3-GR) at the work station of Mr Wasiqi. Mr Wasiqi was welding in the 1G (flat position) and QA noted 200 amps, 27 volts and a travel speed of 278 inches per minute, which was within the stated parameters of the WPS. Genaro Ulloa was FCAW tack welding on the frame of the Door Assembly for Stop 4.

Matt Wasiqi was FCAW CJP welds on the frame of the Door Assembly for Stop 4. Performed a random check of electrical parameters for shop WPS FCAW2915 (B-U3-GR) at the work station of Mr Wasiqi. Mr Wasiqi was welding in the 1G (flat position) and QA noted 195 amps, 26 volts and a travel speed of 270 inches per minute, which was within the stated parameters of the WPS.

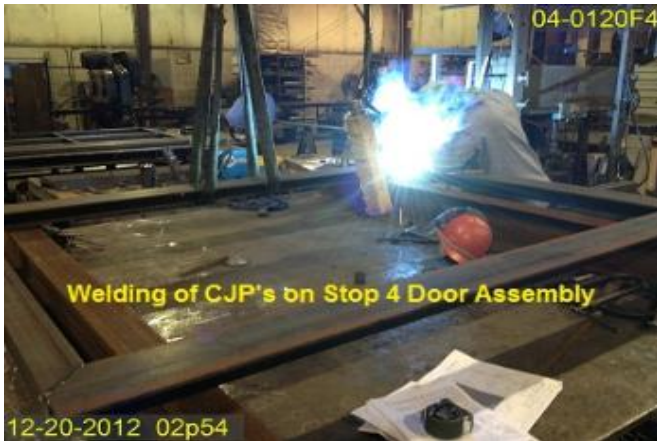
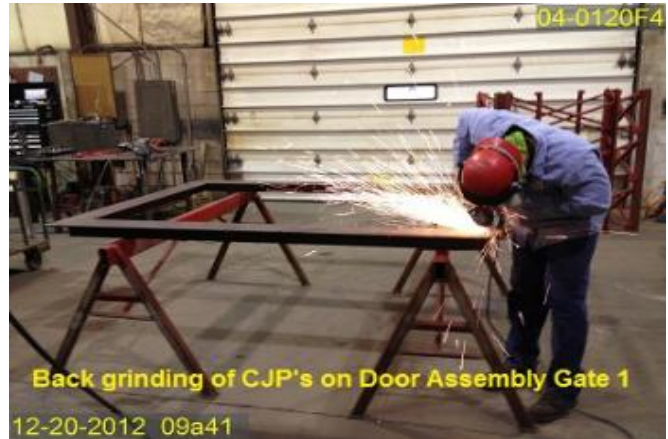
Performed random dimensional inspections on the work performed above which appeared to be in general conformance with the project plans and specifications.

WELDING INSPECTION REPORT

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Received and reviewed Welding Procedure Specifications from Tim Moran, Project Manager at USA Hoist.

Also attached to this report are digital photographs of the QA Inspector's observations.



Summary of Conversations:

As noted within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer